Qty:

Date User Thursday, 3/9/2006 9:23:12 AM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 26187 : 10749

P.O. Number

: N/A

This Issue

: 3/9/2006

Prsht Rev. : NC First Issue

: N/A

S.O. No. : N/A

: 24704

: PURCHASED PARTS

Part Number

Drawing Name

: D33154

: D3315 REV. A PRELIM 0 5. 03. 03

Drawing Number Project Number

: AB 05.03.83

Drawing Revision

Material

Due Date

: NA

: 3/16/2006

: WEARPLATE

5 Um:

Each

Written By

Previous Run

Checked & Approved By Comment

: Est:

05.05.12 New issue KJ/JLM

COMMENT BELOW

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3315 Possible Supplier: Industrial Laser

Material release note is required

11 0602.06



2.0

D33154F

Wearplate Flat Pattern



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)



3.0

PACKAGING 1

WEARPLATE

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

C L06/02/22

PHI

4.0

QC6

DIMENSIONAL CHECK



06.03.68

Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3315-4T1

5.0

SMALL FAB 1

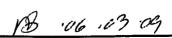
SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



	Dart	Aerospa	ace Ltd
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W/O:			WORK C	RDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·					į		
Part No	:	 PAR #:	_ Fault Category: _		NCR: Yes	No DQ	A :	_ Date:	

QA: N/C Closed: ____ Date: _

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

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NOTE: Date & initial all entries

Job Number: 26187 Part Number: C033154 Seq. #: Machine Or Operation: Description: 6.0 BRAKE NC NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev.	Customer:	CU-DAF	R001 Dant Helio	copters Services	Drawing N	ame: WEARPLA	TE
Do Number Seq. #: Machine Or Operation: 6.0 BRAKE NC Comment: NC BRAKE 1. Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: DIMENSIONAL CHECK 8.0 LARGE FABT LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-473 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description A/R N/A 7560 Hardcoat Rod 9.0 QS Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 11.0 QC3* Comment: INSPECT POWDER COAT 12.0 PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. PN: D33154, BN: BXXXXXX For Product Eligibility see BAD44-47 and Stock P0/10 5-17 Ph 35.05.079 and Stock P0/10 5-17 Ph 35.05.079 AC Comment: VISUAL BED RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. PN: D33154, BN: BXXXXXX For Product Eligibility see BAD44-47 and Stock P0/10 5-17 Ph 35.05.079			*			•	
Seq. #: Machine Or Operation: 6.0 BRAKE IC Comment: NC BRAKE 1-Form using DT8179 Die and DT8157 as per Dwg D3315 Rev. Comment: DIMENSIONAL CHECK 8.0 LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev. Qty Part Number Description AR NA 7560 Hardcoal Rod VISUAL WELDING NSPECTION 10.0 FOWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 11.0 QC3** Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCA-PO, Dart Aerospace Ltd. PAI: D33154, BN: BXXXXX FOr Product Eigibility see PDAG4447 and Stock POPOS - 17 PM 35-05-05-07 POR DAS - 15 - 05-05-05 POPOS - 15 - 05-05-0	Job Number:	26187			Part Nun	nber: D33154	
Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: DIMENSIONAL CHECK 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: DIMENSIONAL CHECK 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description AIR NIA 7560 Hardcoat Rod VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING POWDER COATING POWDER COATING POWDER COATING Comment: NISPECT POWDER (Ref: 4.3.5.6) as per QSI 005 4.3 NISPECT POWDER COAT/CHEMICAL CONVERSION Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. PN: D3315-4, BN: EXXXXX For Product Eligibility see PDA04-47 and Slock POR05-17 PPI 05.05.09	Job Number:						
Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: DIMENSIONAL CHECK 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: DIMENSIONAL CHECK 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description AIR NIA 7560 Hardcoat Rod VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING POWDER COATING POWDER COATING POWDER COATING Comment: NISPECT POWDER (Ref: 4.3.5.6) as per QSI 005 4.3 NISPECT POWDER COAT/CHEMICAL CONVERSION Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. PN: D3315-4, BN: EXXXXX For Product Eligibility see PDA04-47 and Slock POR05-17 PPI 05.05.09							; · ·
Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B B 06 03-09 7.0 QC8 DIMENSIONAL CHECK 8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: CPC 06-03-15 Qty Part Number Description AR N/A 7560 Hardcoat Rod PLEABZ CPC 06-03-15 9.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING POWDER COATING Comment: INSPECT POWDER COAT 11.0 QC3* INSPECT POWDER COAT 12.0 PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. PN: D3315-4, B/N: BXXXXXX FOR Product Eligibility see PBA94-47 and Slock POROS-17 PRI 05.05.05	Seq. #:			n:		Description :	
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Comment: DIMENSIONAL CHECK 8.0 LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description A/R N/A 7560 Hardcoat Rod VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 11.0 QC3** Comment: INSPECT POWDER COAT 12.0 PACKAGING 1 PACKAGING 1 PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-4, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock POA05-17 PM 35.05.09	•			3179 Die and DT8157 as	per Dwg D3315 Rev:	<u>B</u> ,	B 06.03.09
Comment: DIMENSIONAL CHECK 8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-473 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod PLASEZ COMMENT: VISUAL WELDING INSPECTION 10.0 POWDER COATING POWDER CO	7.0	QC6			DIMENSIONAL CHECK		
Comment: DIMENSIONAL CHECK 8.0 LARGE FAB I LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-473 as per QSI 004 and Dwg D3315 Rev: Qty Part Number Description A/R N/A 7560 Hardcoat Rod PLASEZ COMMENT: VISUAL WELDING INSPECTION 10.0 POWDER COATING							
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3315-473 as per QSI 004 and Dwg D3315 Rev: 3 Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod 7/5/8/2 CFC 66-03-/5 9.0 QC9 VISUAL WELDING INSPECTION 10.0 POWDER COATING POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 11.0 QC3* INSPECT POWDER COATIVE INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-4, B/N: BXXXXXX For Product Eligibility see PDA94-47 and Stock POA05-17 PM 35.03.09	Commo	nt: DiMi	ENCLONAL C	HECK			111111111111111111111111111111111111111
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Comment: VISUAL WELDING INSPECTION 10.0 POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 11.0 QG3** INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-4, B/N: BXXXXX For Product Eligibility see PDA04-47 and Stock POROS - 17 PR - 25.03.09	9.0		IN/A	7 500 Hardcoat Rod	VISUAL WELDING INSPE	CTION ,	C C C C C C C C C C C C C C C C C C C
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12.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-4, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock POA05-17 PH 35-03.09	11.0	QC3 ₹			INSPECT POWDER COA	T/CHEMICAL CON	VERSION
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P/N: D3315-4, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock POA05 - 17 PH 05.03.09			•	• •	it fine point marker with	the following:	
For Product Eligibility see PDA04-17 and Stock POA05 - 17 PH 05-03-09							•
and Stock POAOS-17 PH 05.05.0	• •						
			_	POAUS - 17 PH	05.03.09		
Location:							(6/2/21/4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	3			,	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
66-63-14	8	Took 1 D 3315-4 were plate to make D3315-4T3 Welding template Inspected by L 06.03.14	срс	06.0344	(B oren	06:03:14

			QA: N/C Closed:	Date:
Part No: _	PAR #: _	Fault Category:	NCR: Yes (No) DQA:	Date: 06/27/22

NCR:		W						
DATE	07-0	Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User: Thursday, 3/9/2006 9:23:12 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 26187

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Inspection Level 21

Description:

13.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

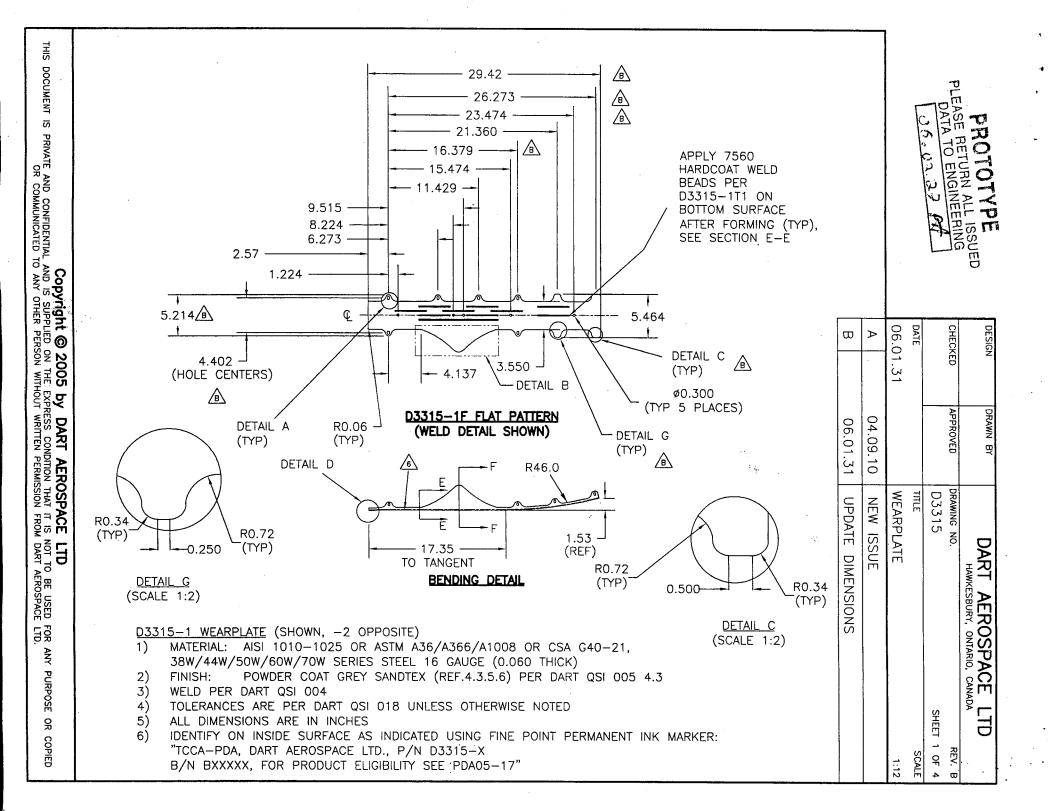


Job Completion

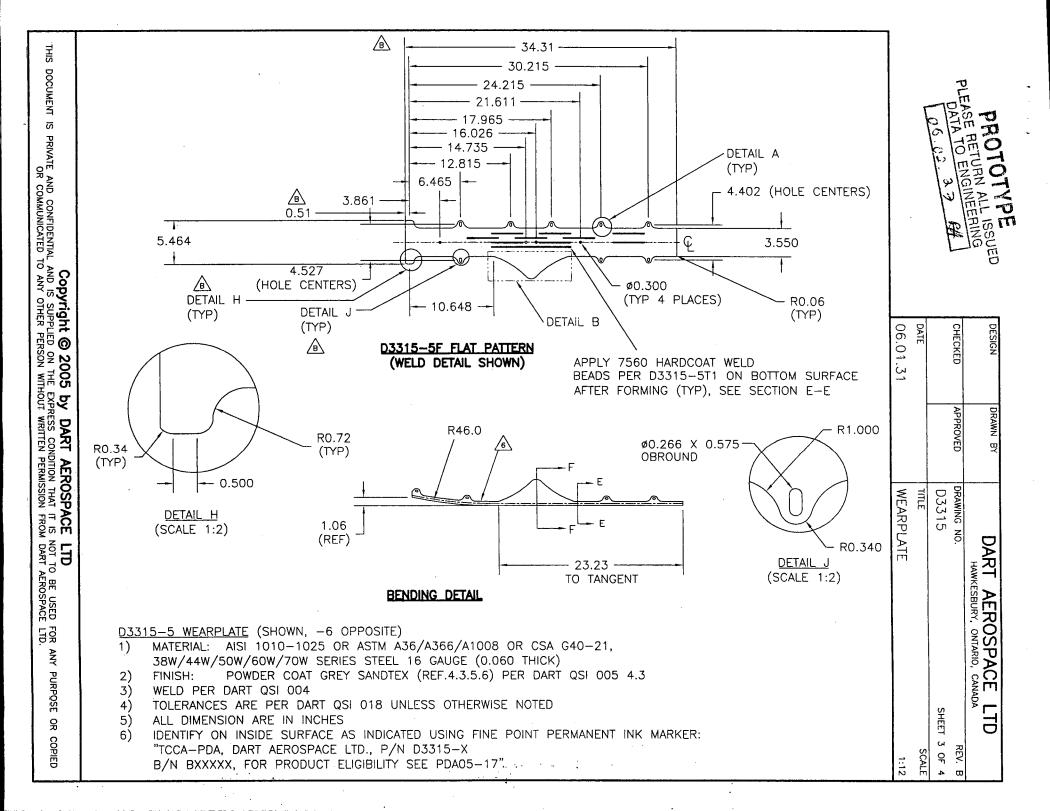


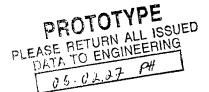
Dart Ae	rospace L	td							
W /O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								ř	
				•					
							<u> </u>		
Part No	-	PAR #:	Fault Cate	gory: NO	R: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	ed:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFORMANC	E (NC	₹)			
		Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8	Sect	tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

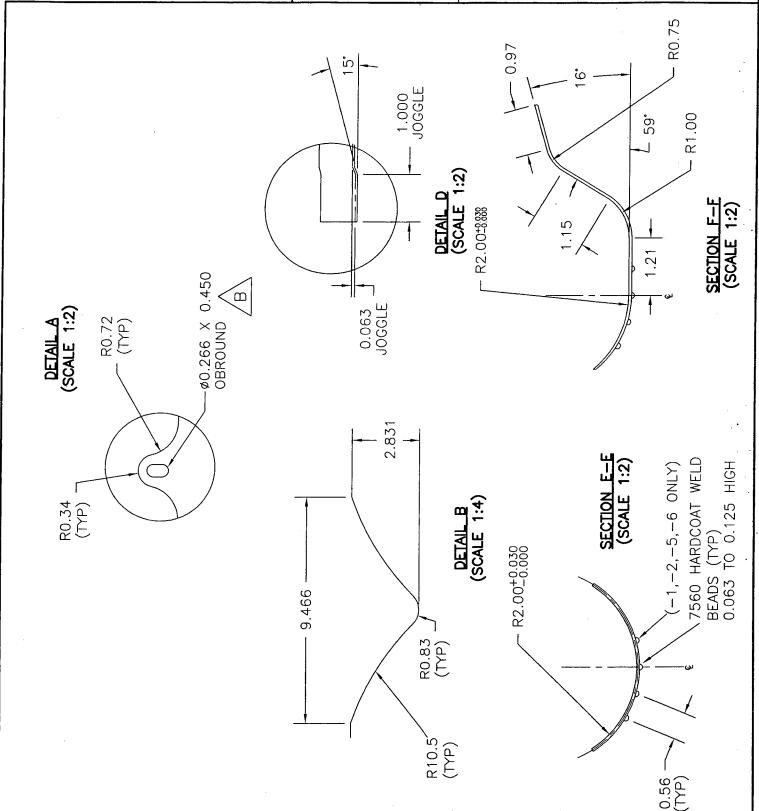


댊 DOCUMENT 62.75 58.094 ᠕ 51.368 ß 44.531 -Copyright @ 2005
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE
OR COMMUNICATED TO ANY OTHER PERSON WITH 37.719 -36.375 30.969 -- 24.188 18.875 17.375 R0.06 (TYP) 10.594 - 5.375 0.875 \B\ 1.62 5.214 4.402 (HOLE 06.01 CENTERS) DETAIL A B APPLY 7560 HARDCOAT WELD . 1 3.550 (TYP) BEADS PER D3315-3T1 ON BOTTOM D3315-3F FLAT PATTERN SURFACE AFTER FORMING (TYP), SEE Ø0.300 (WELD DETAIL SHOWN) DART AEROSPACE
SESS CONDITION THAT IT IS
WRITTEN PERMISSION FROM SECTION E-F (TYP 3 PLACES) D3315 DRAWING NO WEARPLATE DART BENDING DETAIL DETAIL D HAWKESBURY, AEROSPACE L D3315-3 WEARPLATE (SHOWN, -4 OPPOSITE) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21. E S 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK) POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 FINISH: ANY 3) WELD PER DART QSI 004 PURPOSE TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES SHEET IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X COPIED 2 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17 읶





DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
	ļ	D3315	SHEET 4 OF 4
DATE		TITLE	SCALE
06.01.31		WEARPLATE	NTS



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